

# Work Order ID 59156

Thursday, May 27, 2010 9:22:38 AM



Page 1

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 5/27/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-5-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2230	Rev F								
100	BAND SAW	0.00							
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut D2423 extrusion to 0.82" Batch: 75800								
						100			
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS I	0.00							
HAAS CNC vertical machine #1	Memo 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2- deburr rough edges								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
						100			

*cut 10/06/07*

*B.A 10/06/07*

*B.A 10/06/07*

*10.6.8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

LF 10/06/09

100

9



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

100

BR 10-6-10

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

HL 10/06/10

100

~~BR 10-6-10~~

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Page 3

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Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Powdercoat Powder Coating	0.00 Memo START TIME: 9:00AM OVEN TEMPERATURE: 320°F FINISH TIME: 9:30AM		10/06/11		100	0		
170 	QC3- Inspect Part Finish QC Quality Control	0.00 Memo							
180 	Identify as per dwg & Stock Location: 6-A Packaging Packaging	0.00 Memo							

MA 10 06 11 (100)

ES 10/06/11 (100)

W/O:		WORK ORDER CHANGES					
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Page 4

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/15

MF

10-6-14

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



# Picklist Print

Thursday, May 27, 2010 9:22:43 AM

Page 1

Work Order ID: 59156



Parent Item: D2230-1



Parent Item Name: Lug

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP ☐ D ☐ 00.11.01 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	470.5321	0.0683	7.189474			



Lug Extrusion



Location

Loc Qty

Loc Code

MAT06

470.5320795

43722

180

→ 45800

290.532079

7.1895 *2-10/06/07*

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NOTE: Date & initial all entries



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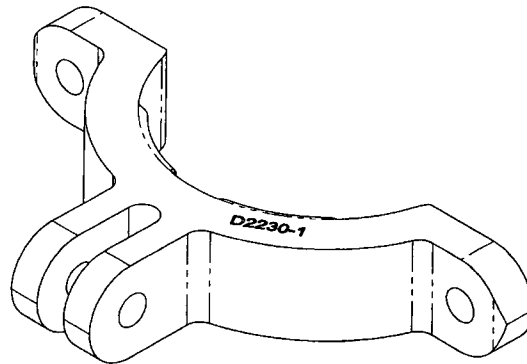
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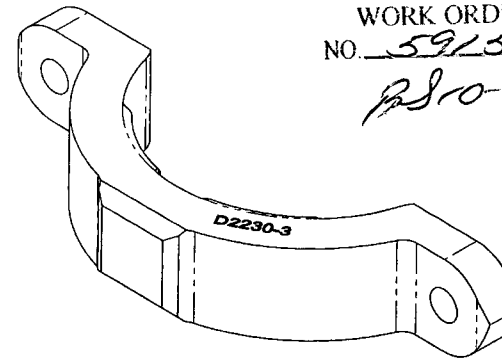
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**NOTE:** Date & initial all entries

SHOP  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59156  
PS10-527



**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

**RELEASED**  
09/06/15 M

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

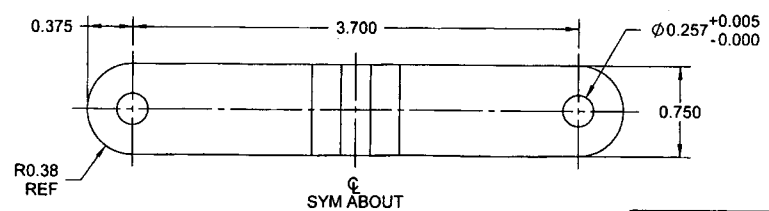
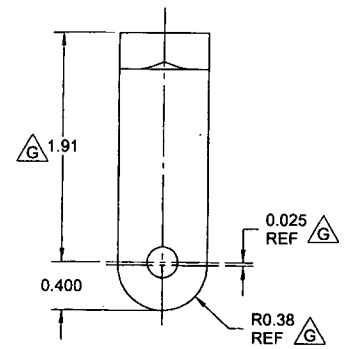
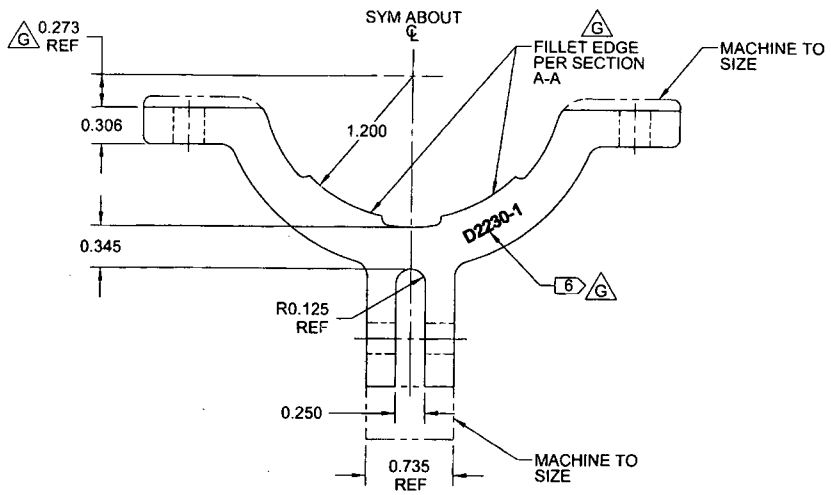
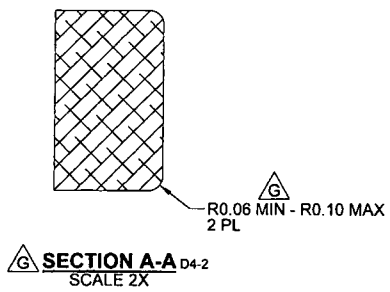
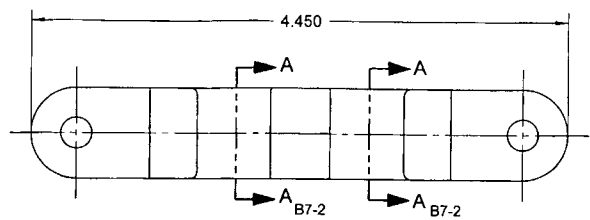
A

D

C

B

A



**D2230-1 MOUNTING LUG**

*W/1059154*

**RELEASED**  
09/06/75

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D2230</b>	REV. G
MFG. APPR.		TITLE <b>MOUNTING LUG</b>	SCALE NTS
APPROVED		<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.			
DATE	09.01.16		

8 7 6 5 4 3 2 1

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**NOTE:** Date & initial all entries



8

7

6

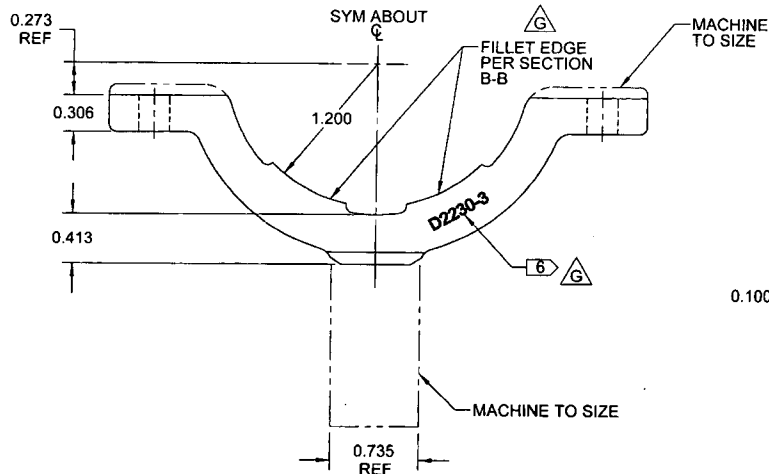
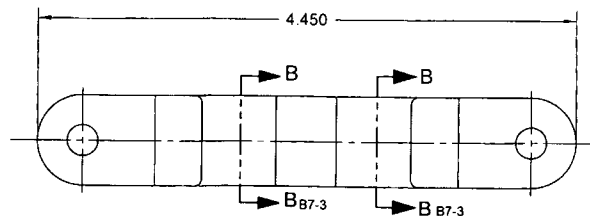
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4

3

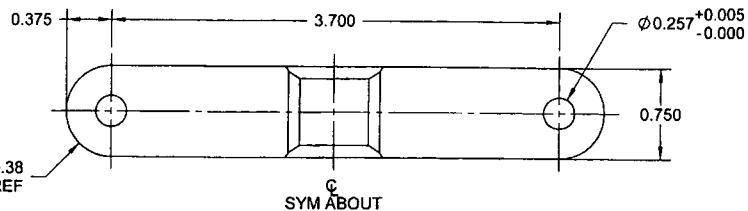
2

1



**SECTION B-B**  
SCALE 2X

R0.06 MIN - R0.10 MAX  
2 PL



**D2230-3 MOUNTING LUG**

W 1059159

**RELEASED**  
09/06/2014

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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